

Work Order ID 163914

Monday, July 10, 2017 12:44:13 PM

163914

Page 1

Item ID: D3849-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-On Landing Wearplate Fwd for Standard Skidtubes

Start Date: 7/19/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: DAS Date: JUL 12 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3849	F

110 Weld per dwg A/R S.S. rod Batch: M134992 0.00***110***

Large Fab

Memo

0.96

Large Fab

1- Weld D3901-041 bar to wearplate as per dwg D3849
304 S.S. Welding Rod
BATCH #: M134992

2- Transfer drill holes as per dwg

3- Cut excess bar material if necessary

(4)

DYK
1707/28

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

(4)

1707-31DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>50</u>	<u>17-0731</u>		DAS 9 9-89
140 *140* Small Fab Small Fab	1- Apply a layer of TEXTURE COATING as per dwg Memo BATCH: <u>137803</u>	0.00 0.54				<u>4</u>			DAS 41 9-89 AUG 02 2017
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>4</u>			DAS 38 AUG 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
58.4								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	Positioned Wrong ☐																
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160	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
160									
Packaging	Memo	0.02							
Packaging	LOCATION : FP002								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89
AUG 03 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Monday, July 10, 2017 12:44:11 PM

163914

D3849-041

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC IPP Rev:B
12.09.11 AS PER DWG REV.D DD VERF:JLM IPP Rev:C 14.11.26
AS PER DWG REV.E DD VERF:JLM IPP REV:D 16.06.17 DWG
REV.F DD VERF:JLM

[illegible]

DQA: _____ Date: _____

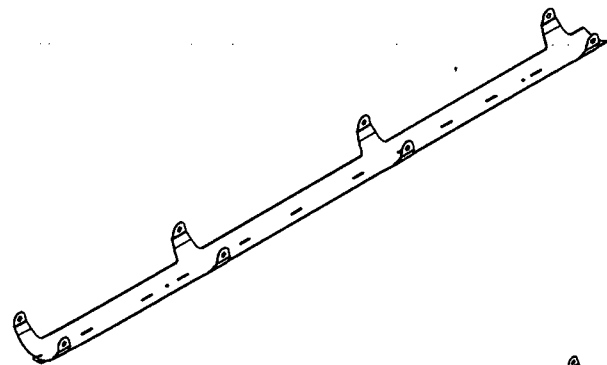


WORK ORDER NON-CONFORMANCE / UPDATE

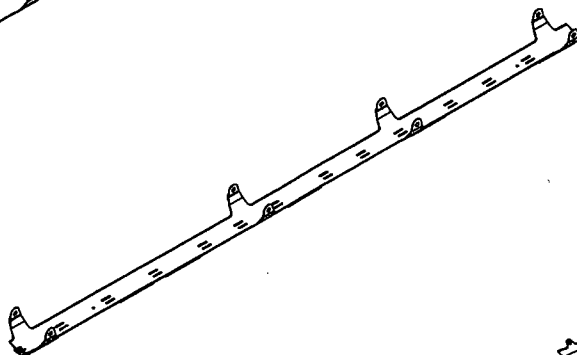
QA Closed: _____ Date: _____

Work Order update only ☐

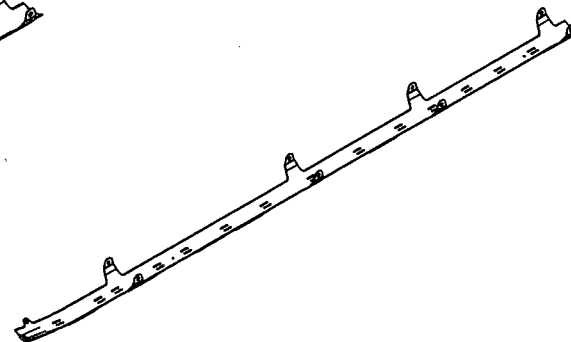
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OTHER : ☐																									



D3849-041 FWD WEARPLATE ASSY, STD GEAR

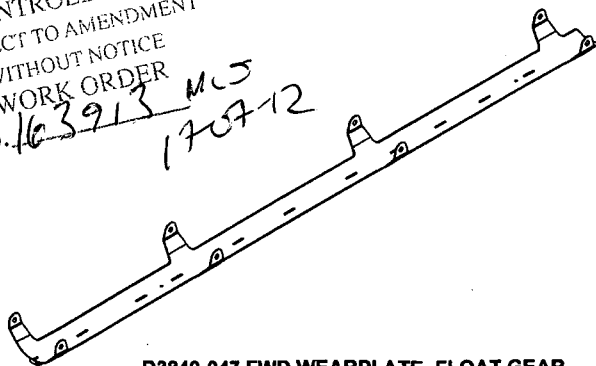


D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163913 M.C.S
1707-12



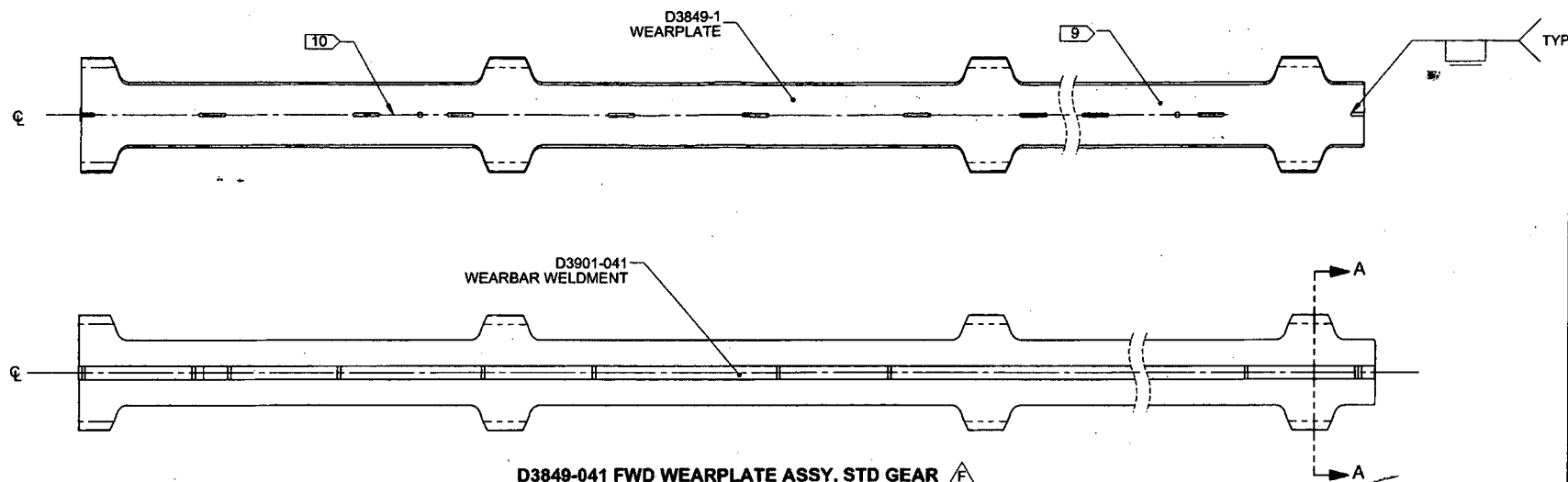
D3849-047 FWD WEARPLATE, FLOAT GEAR

RELEASED
2016-06-16
EEN 16-594

F	HARD SURFACING MOVED TO DRAWING D3801 FOR AUTOMATED WELDING. ALL VIEWS UPDATED ACCORDINGLY. SHT 6 FLAT PATTERN VIEW DIM 54.45 WAS 54.26, DIM 51.50 WAS 51.31 ADD 15.50 REF DIM. SHT 7 FLAT PATTERN VIEW B3-B2 CHANGED SLOT PITCH. UPDATE NOTES ALL SHEETS.	AJS	16.01.05
E	TEXTURED COATING WAS 4714 ROCKGUARD (BOM TABLE). CHANGE NOTE 10 (SH 2, 3, 4, 5), 8.49 LBS WAS 7.66 LBS (SH 3, NOTE 7), 10.25 LBS WAS 8.93 LBS (SH 4, NOTE 7), 4.66 LBS WAS 4.60 LBS (SH 5, NOTE 7)	AK	14.08.07
D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3801-1/3-5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9)	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS. ADDED DOUBLE SLOTS AND D3801-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3848-1/3-5/7 GASKETS, ADD ROCKGUARD COATING, REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3848-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10). ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9). ADD SECTION K-K (ZN C5-10). 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10). ADD 0.25 & 0.88 (ZN D4-10, D3-10). ADD 0.88 & 0.44 (ZN C5-10 & B3-10). ADD FLAG NOTE (ZN A6-2, C6-2, C3-2, A6-3, C6-3, C3-3, A6-4, C6-4, C2-4). 68.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DD	D3849	SHEET 1 OF 10
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.01.05	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D3849-041	FWD WEARPLATE ASSY, STD GEAR
1	1	D3849-1	WEARPLATE
2	1	D3901-041	WEARBAR WELDMENT



NOTES:

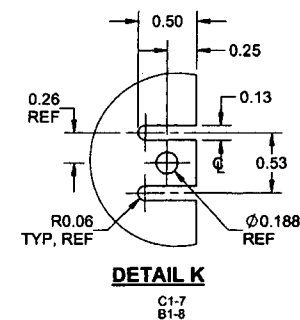
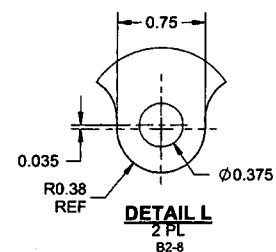
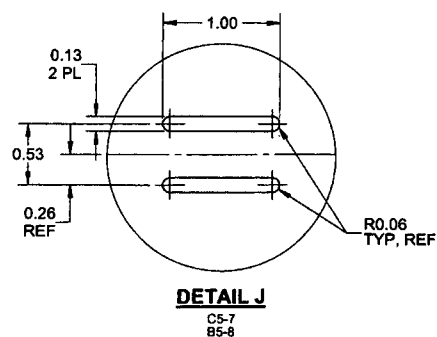
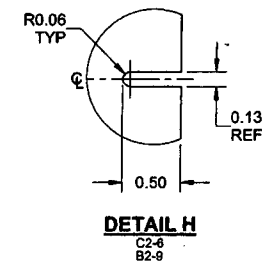
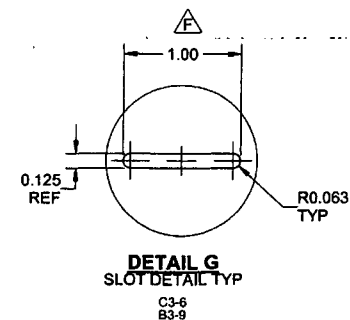
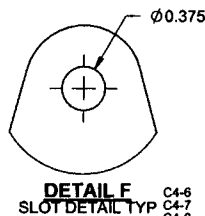
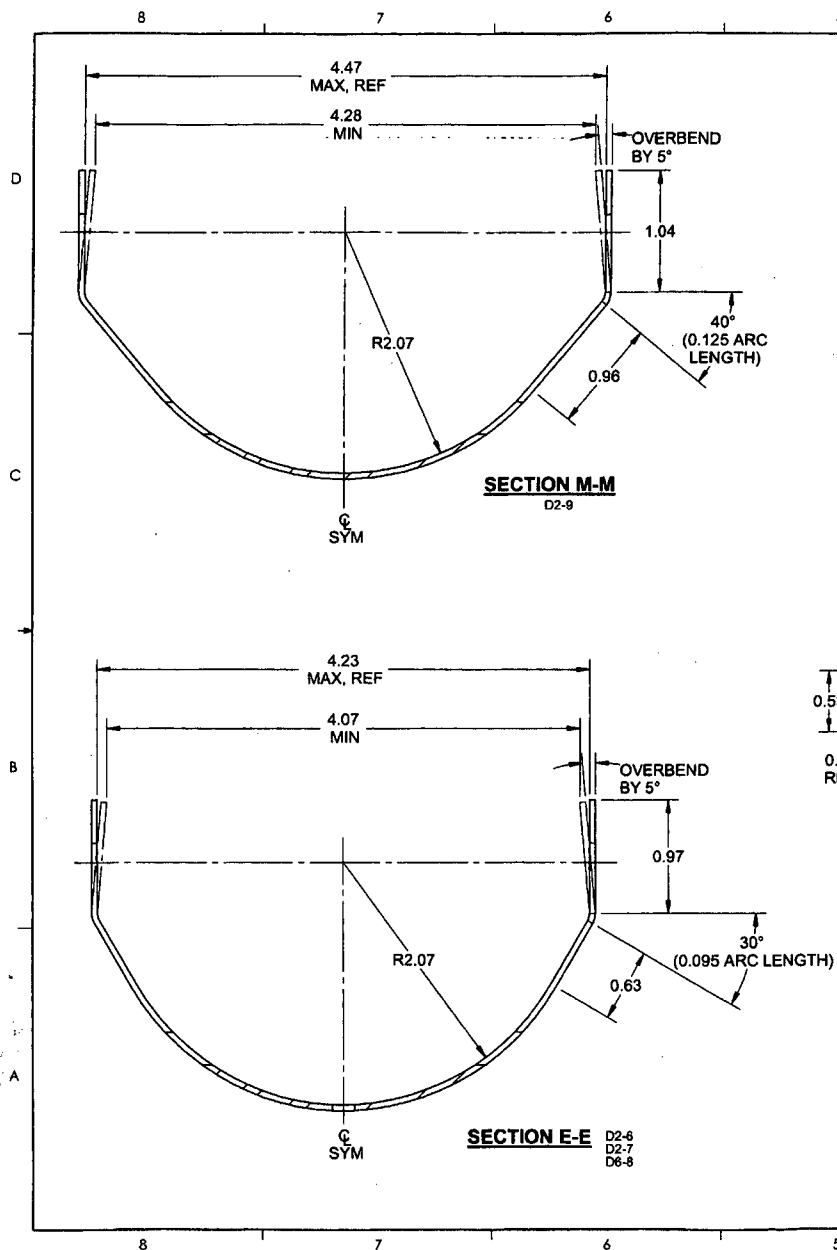
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.82 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 WEARPLATE TO D3901-041 WEARBAR, AFTER APPLYING TEXTURED COATING.

SECTION A-A

RELEASED
2016-06-16

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
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